

# Work Order ID 57270

Wednesday, March 31, 2010 11:24:09 AM



Page 1

Item ID: D3911-043

Accept



Setup Start



Revision ID:

Item Name: Basket Installation Stud Assembly, Upper

Stop



Start Date: 3/31/2010 Start Qty: 6.00



Required Date: 4/5/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:  
Customer:

*Scrap*

Run Start



Stop



Approvals: Process Plan: *mf*

Date: *10-4-1*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3911

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble D3911-5 to D3911-3 and install rivet as per dwg  
Trim rivet to 1.250" Full Length

*4/5/04/05* (6)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*SAD*

*5/10/04/05*

(76)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 57270**

Wednesday, March 31, 2010 11:24:09 AM



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Item ID: D3911-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Installation Stud Assembly, Upper

Start Date: 3/31/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 4/5/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Identify as per dwg & Stock Location: <u>S09</u>	0.00							
Packaging	Memo	0.00							
Packaging									
160 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Scrap

per ECN

10-545

10/4/6

(6)

MF 10-4-16

MF 10-4-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, March 31, 2010 11:24:09 AM

Page 1

Work Order ID: 57270



Parent Item: D3911-043



Parent Item Name: Basket Installation Stud Assembly, Upper

Start Date: 3/31/2010

Required Date: 4/5/2010

Comments: IPP RevA: New issue DD verified by:EC  
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3911-5		Manufactured	No			100	Each	20.0000	12.0000			

Basket Stud Plate

*N/A 10.04.01*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST095

20

57119

20

D3911-3

Manufactured No

100

Each

8.0000

6.0000



Aft Eyebolt Receiver

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST095

8

57064

8

MS20615-4M20

Purchased No

100

Each

80.0000

18.0000



RIVET

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST323

80

113254

80

*M 114304*

*(18) 80 10/04/05*

*pull all parts & scrap*

*UWF 10-4-05*

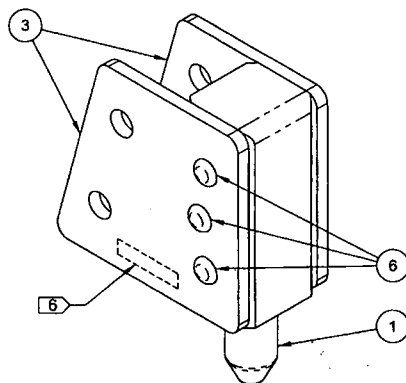
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		Add. D 3911-7 D 4087-1. MS2109-C610	<del>x #2</del> <del>x #2</del> <del>x #2</del>	B 57120. B 56972 B 108847	x 20. x 20. x 20.	MF	10-4-5		
		Scrap all parts & remaining pull from stock			MF	10-4-14			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: per ECU 10-545 NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		D 4085-1 B 56982	13	Scrap no-good. change drawing	MF 10-4-16			

NOTE: Date & initial all entries

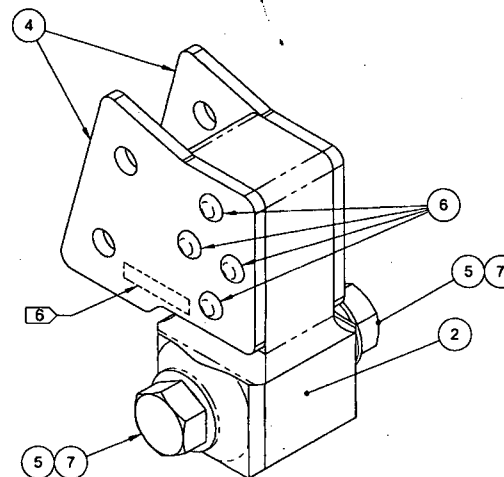
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3911-041	BASKET INSTL STUD ASSY (LOWER)
		X	D3911-043	AFT EYEBOLT RECEIVER ASSY
1	1		D3911-1	BASKET INSTL STUD (LOWER)
2		1	D3911-3	AFT EYEBOLT RECEIVER
3	2		D3911-5	BASKET STUD PLATE
4		2	D3911-7	BASKET PLATE-EYEBOLT RECEIVER
5		2	D4087-1	CAP SCREW, PLASTIC, 3/8"x16
6	3	4	MS20615-4M20	RIVET
7		2	MS21209-C610	HELICAL



**D3911-041 BASKET INSTL STUD ASSY (LOWER)**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3911-04X USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 0.63 lbs  
-043: 1.17 lbs



# 57210

**D3911-043 AFT EYEBOLT RECEIVER ASSY**

**RELEASED**  
2010-03-22  
MP

B	DIAMETER (B3-2) AND DIM ADDED (B2-2) & (C3-2)	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN	JPH		
CHECKED	JPH		
MFG. APPR.	JPH		
APPROVED	JPH		
DE APPR.	JPH		
DATE	10.03.16		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3911** REV. B  
SHEET 1 OF 3

TITLE **AFT HARDPOINT, BASKET** SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

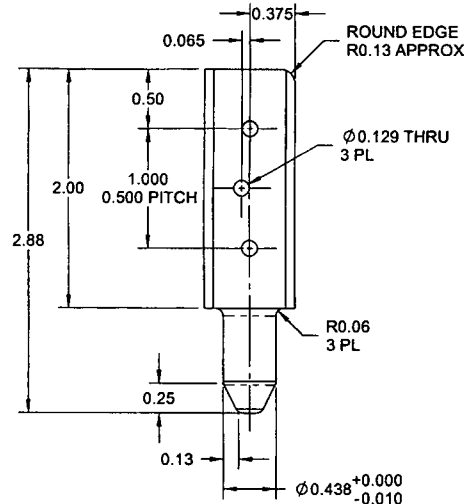
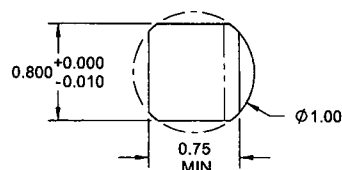
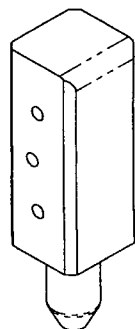
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



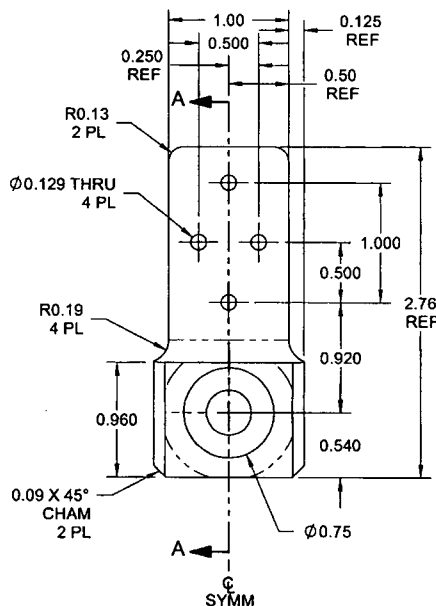
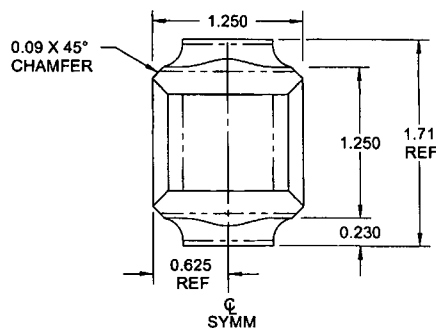
8 7 6 5 4 3 2 1



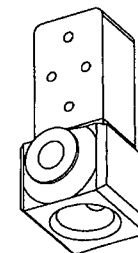
**D3911-1 BASKET INSTL STUD (LOWER)**

**NOTES:**

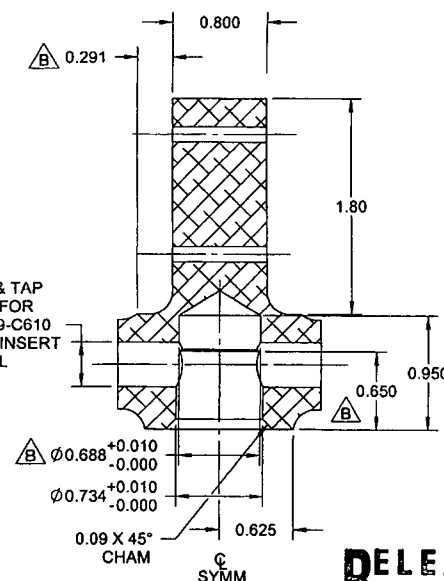
- 1) MATERIAL -1: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276  
PER DART SPEC M303R OR M304R
- 3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276  
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -1: 0.36 lbs  
-3: 0.74 lbs



**D3911-3 AFT EYEBOLT RECEIVER**



DRILL & TAP  
3/8-16 FOR  
MS21209-C610  
HELICAL INSERT  
2 PL



**SECTION A-A**

**RELEASED**  
2010-03-22

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3911	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		AFT HARDPOINT, BASKET	NTS
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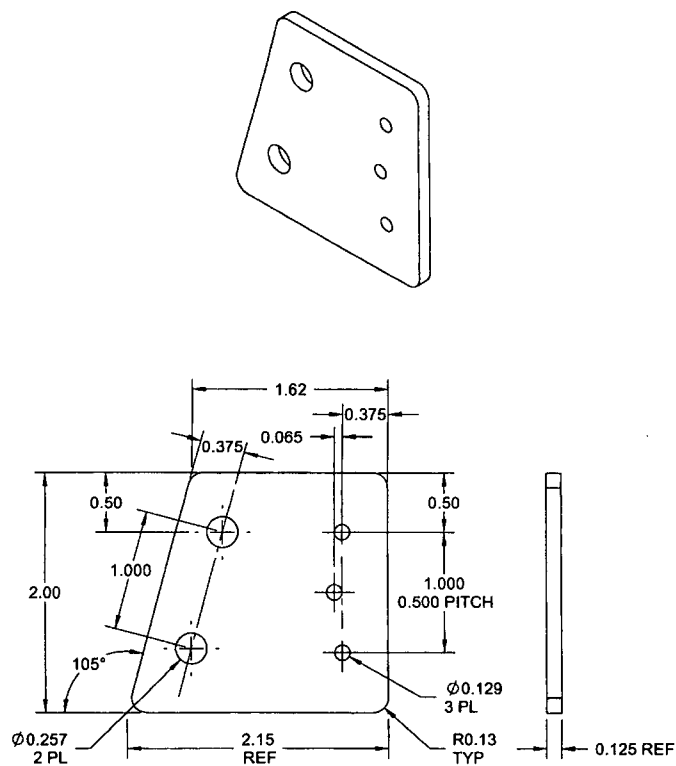
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

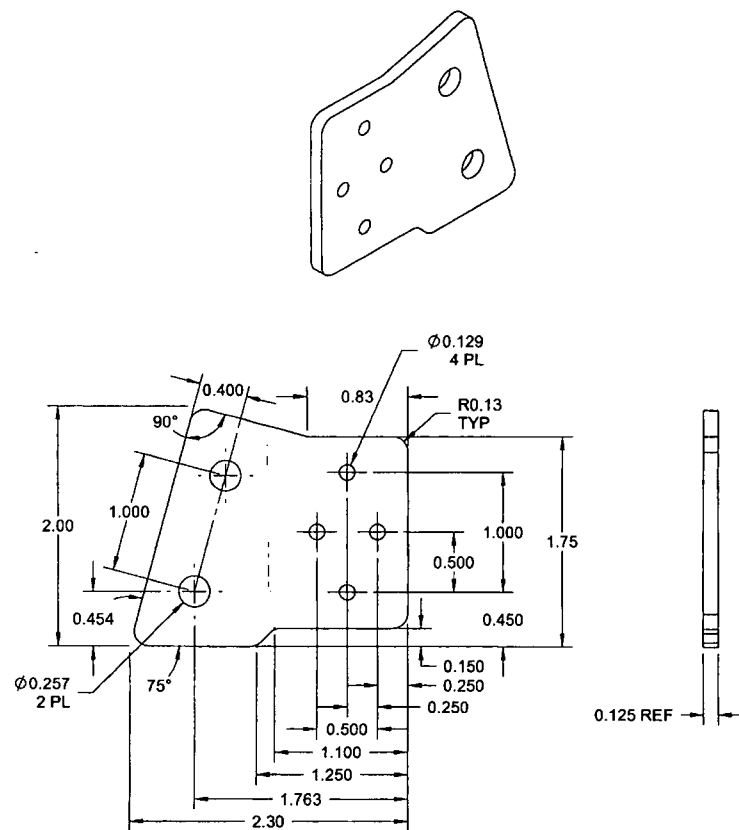
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3911-5 BASKET STUD PLATE**



**D3911-7 BASKET PLATE-EYEBOLT RECEIVER**

**NOTES:**

- 1) MATERIAL -5 & -7: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240  
PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.13 lbs  
-7: 0.13 lbs

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.		D3911	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		AFT HARDPOINT, BASKET	NTS
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**RELEASED**  
2010-03-22  
AND

#57270

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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